Work Ordo	er ID 90645			*906	345*				, <u> </u>			Page 1	
Item ID: Revision ID: Item Name: Start Date:	D350-561-141 Single Cargo Mirror 9/21/12 Star	Installation, RH,	6 inch Round * 1 *	Accept	*N900	·	100)*	Setup	Start Stop	*N:	S1* S2*	
Required Date: Reference:		l'd Qty: 1.00	*1*		Customer:								
Approvals:	Process Plan:		Date: <u> 2-09</u> -Z			ate:	<u> </u>		Run	Start Stop	*N *N	R1* R2*	
Sequence ID/ Work Center II		ration cription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt		Reject Number	Insp. Stamp	
Draw Nbr	Revision	Nbr	· · · · · · · · · · · · · · · · · · ·										-
N/A 100 *1 \\ DC Document Control	Rev N/A	Memo Photocopy b		0.00 0.00 er PPP D350-561-141	CHG000) doeles			Ð	41,	MLJ	-12-9	- 3- <i>2</i> ,
*105 *105* Packaging Packaging	Pick l	Kit Memo		0.00								12/09/	or f
110 *110* QC Quality Control	QC4-	- 100% Inspect kits Memo	for completeness	0.00	docho			- (i) —				

											DQA:	Date	:
NCR:	Yes	/ No				WORK ORDER NON-	·COI	NFORM	MANCE / UP	DATE	QA Closed:	Date	:
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part I	No.					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root			T		Nescri	ption of work order update	1	Initial	Δς	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance		nief Eng	Į.	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								IT CATE	CODY				
Landi	ina (Gear			·	General	FAUI	LT CATE	GURT				
Lattu	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Wayes in Extrusion				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misreae Offset	ion Incomplete tions Incomplete/ enance eled d	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
1	Torque Waves in Extrusion					Drawing	- 1	Out of	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish Folio

September-21-12 11:29:50 AM				907	14:1						
Item ID: Revision ID:	D350-561-1	141	-	Accept	*N900	040	100)*	Setup Sta	rt *N	S1*
Item Name:	Single Cargo	Mirror Installation, RH,	6 inch Round						Sto	^p *N	S2*
Start Date:	9/21/12	Start Qty: 1.00	*1*		Cust Item I	D:					
Required Date:	10/05/12	Req'd Qty: 1.00	*1*		Customer:						
Reference:							_		5		
Approvals:	Process Pl	lan:	Date:	Tooling:	D:	ate:	- ·	ļ	Run Sta	1/1	R1*
	QC:		Date:	_ SPC (Y/N):	Da	ate:			Sto	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		De des des		0.00						1	
120 Packaging		Packaging Memo		0.00					-/	12/9/2	6 (1)
`Packaging		Identify and	pack for shipping as per	PPP D350-561-141					/	7 40	
			PP 1900	190							. ^
130		QC21- Final Inspection	- Work Order Release	0.00					121	19/2	8
130		Memo		0.00					101		

Quality Control

MUS 12-09-27

												DQA:	Date	e: _	4 4 7
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPI	DATE					
												QA Closed:	Date	9:	
Work Ord	or.					DISPOSITION				AGAINST I	DE	PARTMENT	PROCESS		
Work Ord	C1.		· · · · · · · · · · · · · · · · · · ·			Rework	7		Skid-tube	Crosstube			Water Jet		Engineering
Part	No.					Scrap	1	i	Machining	Small Fab		Pro	d. Eng. Coor.	7	Quality
						Use-as-is]	Therm	noforming	Finishing		Rec/Stor	re/Packaging		Other
NCR	No.					Work Order Update]		Large Fab	Composite			Supplier		
			1	1	Descri		Т.	la ista l	A	:		Cian 0		7	
Root		D-4-	C+	04.		ption of work order update	i	Initial		ion		Sign & Date	Verification		QC Inspector
Cause	I	Date	Step	Qty		or Non-conformance	T Cr	nief Eng	Desci	ription		Date	verification	\dashv	QC IIIspector
Doc/Data	<u> </u>														
Equip/Tooling	\vdash													ļ	
Operator	├-														
Material	\vdash		<u> </u>		-										
Setup	├						1								
Other	⊢		}												
Process	⊢														
Supplier	-														
Training	-	<u> </u>	}									ļ			•
Unapproved	<u> </u>	L	1	<u> </u>				T CATE	CORV			1	1		
Landi	na (Gear				General	AUI	LICAIL	GONT			•			
Land		Bending				Bend		Grain	-	•		Ovalized	Γ		Pressure/Forced
	\vdash	4 -	ot Concer	ntric to ()/s	BOM/Route	-	Hardwa	ire			Over/Under	tolerance		Temperature/Cure
	\vdash	Centre Not Concentric to O/S Cracks			-	Broken/Damaged	-	4	ion Incomplete	ŀ		Part Incorre	<u> </u>		Weld
	\vdash	ł	Crimped		-	Burrs	\vdash	-	ions Incomplete/	Unclear		Part Lost/M	-		Wrong Stock Pulled
	Crushed/Crimped. Cuffs				Contamination		Mainte	•			Part Moved			1	
	\vdash	Heat Trea	ıt			Countersink		Mislabe		ŀ		Positioned V	Vrong		
	H	Inspection Strip in Tube			<u> </u>	Cut Too Short	-	Misread				Power Loss/			Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Work Order ID:

90645

Parent Item:

D350-561-141

Parent Item Name:

Single Cargo Mirror Installation, RH, 6 inch Round

Start Date: 9/21/12

Required Date: 10/05/12

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP A 07.07.26 new issue (DSI9379) EC verified by:JLM IPP rev B 10.02.16 per ecn 10-523 EC verified by: DD IPP Rev:C add pick kit DD 10.03.15 verified by:EC

Rev:D 10.09.14 per IIN revD DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on e Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
Ð2011-101		Manufactured	No			105	Each	51.0000	1		<i>U</i>		
6" Mirror		Manufactured							(110) - 174 - 174		1B		
				Location		Loc Qty	<u>I</u>	Loc Code			O		
				ST226		1							
				799	43	i							
/				ST229		50				, 117			
,				866	47	50			86	647			Ø n
D2012-105 Arm		Manufactured	No			105	Each	6.0000	1	1	11		SP)
74111				Location		Loc Qty	<u>1</u>	oc Code			0 -		
				ST229		6							
				794	64	6			7	7464			
D2012-107 Clevis		Manufactured	No			105	Each	17.0000	1 - 24	55 f	20	г ж ж л.	
				Location		Loc Qty	<u>I</u>	oc Code			•		(51
				WA005		17							
				858	62	17			85	862			
D2012-111 Bracket		Manufactured	No			105	Each	25.0000	1	1	JB		
				Location		Loc Qty	Ī	oc Code			-		
				ST003		25				(a 5 /			
/				707		1			_70	1726			
			N1-	825	91	24 105	Each	12.0000			<u> </u>		
D2012-115 Bracket, Clevis		Manufactured	No			103	Еасп	12.0000	1	I	26	16	409/26
Brucket, Clevis				Location		Loc Oty	I	Loc Code				•	409/26
				ST003		12							109
				860	66	12			8	6066			

NCR:	⁄es	/ No				WORK ORDER NON-O	CON	NFORM	MANCE / UPI	DATE	QA Closed:	Date	:
Work Orde	er:					DISPOSITION Rework	,		Skid-tube	AGAINST D	EPARTMENT,	/PROCESS Water Jet	Engineering
Part N	,					Scrap Use-as-is Work Order Update		f Therm	Machining noforming Large Fab	Small Fab Finishing Composite		d. Eng. Coor. re/Packaging Supplier	Quality Other
Root Cause		Date	Step	Qty		ption of work order update or Non-conformance		nitial ief Eng	Act Descr	ion iption	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							AUL	T CATE	GORY				
Landi	Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion					General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	ion Incomplete ions Incomplete/U enance eled	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

September-21-12 11:29:48 AM

Work Order ID:	90645										
Parent Item:	D350-561-141						Start	Date: 9/21/12		Required Date:	10/05/12
Parent Item Name:	Single Cargo Mirror Installation, RH	, 6 inch R	Round				Start	t Qty: 1.00		Required Qty:	1.00
D2022-101 Spacer	Manufactured	d No			105	Each	51.0000	2	2	-JB	X
			Location	<u>1</u>	Loc Oty		Loc Code			•	01
			ST004		50)					
				83995	50)		839	795		
			ST504			l					
				73307		1					
D3629-1 Bracket	Manufactured	d ^{No}			105	Each	4.0000	1	1	~ gB	8
			Location	<u>1</u>	Loc Qty		Loc Code				
			ST245A		4			_			
				76270	4	4		76	270		
D3635-1 Gasket	Manufactured	d No			105	Each	14.0000	1	1	13	8 @
) Gusker			Location	1	Loc Qty		Loc Code			•	O :4
			ST059	_	14						
			5,000	70764	14			70	764		
D3646-1 Arm	Manufacture	d No			105	Each	6.0000	1	1	70	
			Location	1	Loc Qty		Loc Code				24
			ST229	_		6					
			0	82594		6		825	594		
D3646-3 Arm	Manufacture	d ^{No}			105	Each	6.0000	1	1	JB.	80)
			Location	n	Loc Qty		Loc Code			v	
			ST229	_		6					
			0.22	79356		2		795	356		
,				82592		4					
D4070-041 Clamp	Manufacture	d ^{No}			105	Each	6.0000	2	2	jo	12/09
,			Location	<u>n</u>	Loc Qty		Loc Code			•	TO.
			ST457			6		_			OK.
				89264		6		99	264		

NCR: Ye	es / No	
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DQA: ____ Date: ____ #

NCR: Y	es / No				WORK ORDER NON-C	ONFOR	IVIANCE / UP		QA Closed:	Date	<u>:</u>
Work Orde	r·				DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
ert N					Rework Scrap		Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality
NCR N	0				Use-as-is Work Order Update	The	moforming Large Fab	Finishing Composite	Rec/Sto	e/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	Ad	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Desc	cription	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling											
Operator											
Material											
Setup											
Other									:	ļ	
Process	_										
Supplier											
Fraining					·	}					
Unapproved		L	<u> </u>						Ļ		
						AULT CAT	EGORY				
Landin	g Gear			_	General				7	_	
	Bending			<u> </u>	Bend	Grain		L	Ovalized	L	Pressure/Forced
ļ	Centre N	ot Conce	ntric to C	D/S	BOM/Route	Hard			Over/Under	-	Temperature/Cure
]	Cracks			ļ	Broken/Damaged		ction Incomplete	·	Part Incorre	-	Weld
	Crushed/	Crimped			Burrs		ctions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs Contamination					\vdash	tenance		Part Moved		
	Heat Treat Counte			Countersink	Misla	beled		Positioned \			
	Inspectio	-	Tube		Cut Too Short	Misre			Power Loss,	'Surge	Other
Ripples in Bend Drill Holes				Drill Holes	Offse	t				· · · · · · · · · · · · · · · · · · ·	
	Torque V			۱	Drawing	_	f Calibration				
	Turning S	Sequence			Finish		f Sequence				······································
Wave/Twist in Tube					Folio	Outsi	de Dimensions				

September-21-12 11:29:49 AM

Work Order ID:	90645										
Parent Item:	D350-561-141					Start D	ate: 9/21/12		Required	Date:	10/05/12
Parent Item Name:	Single Cargo Mirror Installation, RH,	6 inch Round				Start (Qty: 1.00		Required	l Qty:	1.00
AN3-5A Bolt	Purchased	No		105	Each	1,404.0000	6	6	19	<u>B</u>	8 P
O		Loca	<u>tion</u>	Loc Qty		Loc Code					
		ST35	0	1404							
			115371	46							
			117423	121							
			119355	200							
			120187	60							
			121185	6							
			122416	500				(7.4.4)			
			122800	471			100	800			
AN3-6A Bolt	Purchased	No .		105	Each	315.0000	1	1	J	B	
·		Loca	<u>ition</u>	Loc Oty		Loc Code					
		ST35	31	315							
			117441	34							
			121060	18			1210	60			
			121166	13							
			122814	200							
			122993	50							
AN4-5A Bolt	Purchased	No		105	Each	801.0000	3	3	V J	В	
,		Loca	tion	Loc Qty		Loc Code			0		
		ST35	55	801							
			120562	801			120.	562			
AN4-10A D Bolt	Purchased	No		105	Each	104.0000	1	1	11	3	12/09/2
U Bon		Loca	tion	Loc Qty		Loc Code		-	0		8
		ST35		50							<u>@</u>
		313.	122407	50							
		ST35									
		8133		54							
			117619 122800	4 50			122	(1) A			
			122000	30			100	000			

											DQA:	Date:	<u></u>
NCR:	Yes	/ No				WORK ORDER NON-	CON	NFORN	MANCE / UPDATE		QA Closed:	Date:	
Work Orde	or:					DISPOSITION			AGAIN	NST DE	PARTMENT,	/PROCESS	•
Part I	٠ ِ No.		,			Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Crosstu Machining Small I noforming Finish Large Fab Compos	ab ing		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root						ption of work order update	1	nitial	Action		Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved									(
						F	AUL	T CATE	GORY				
Landi		1				General		7		,	٦		٦ .
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube				o/s	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misreac	on Incomplete ions Incomplete/Unclear enance eled		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N Power Loss	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	-	Ripples in Bend				Drill Holes	\vdash	Offset	Calibration				

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish

September-21-12 11:29:49 AM

Work Order ID: Parent Item:	90645 D350-561-141							Start D	pate: 9/21/12	Required Date:	10/05/12
Parent Item Name:	Single Cargo Mirror	Installation, RH,	6 inch Ro	ound					Qty: 1.00	Required Qty:	
AN960JD10 Washer	NAS1149D0363J	, Purchased	No			105	Each	0.0000	8 122378	10	SEC
AN960JD416 Washer	NAS1149D0463J	Purchased	No			105	Each	29.0000	8 122452	~ 1B	&
S				Locatio	<u>n</u>	Loc Qty		Loc Code			- •
				ST351		29					
					116289 119097	8 21					
MS21042L3 Nut		Purchased	No			105	Each	2,556.0000	4 4	135	F
,				Locatio	<u>n</u>	Loc Oty		Loc Code		•	0,
				316		719					
					122452	719					
				ST300		574					
					117885	32					
					119017	404				•	
					119075	138					
				ST317		1263			122141		
/					122141	1263		(170 0000	100171	_	
MS21042L4 Nut		Purchased	No			105	Each	6,178.0000	4 4	JB	12/09/20
				Locatio	<u>n</u>	Loc Qty		Loc Code			<u> </u>
				314		3147					•
					122452	3147			122452		
				FP001		4					
					8182	4					
				ST300		27					
					119017	20 7					,
				eres s	121444						
				ST314	123021	3000 3000					
					143041	3000					

											DQA:	Dat	:e: _	🕶 ٿير	
NCR:	Yes /	No No				WORK ORDER NON-O	CON	NFOR	MANCE / UPDATE						
											QA Closed:	Dat	te:		
Work Order:						DISPOSITION		AGAINST DEPARTMENT/PROCESS							
						Rework	1 		Skid-tube Crosstube	. [Water Jet		Engineering	
Part No.						Scrap	1	Machining Small Fab			Prod. Eng. Coor.			Quality	
· u.c.						Use-as-is	┨ ┃		noforming Finishing	-	l	e/Packaging		Other	
NCR No.						Work Order Update]		Large Fab Composite		·	Supplier			
					,		لًـــ				·				
Root						ption of work order update	1	nitial	Action		Sign &		Ì		
Cause	.	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description		Date	Verification	<u> </u>	QC Inspector	
Doc/Data	Ш														
Equip/Tooling	Ш														
Operator	Ш						İ								
Material	Н				i										
Setup	Н												ĺ		
Other	H												1		
Process	Н														
Supplier	Н												ı		
Training	\vdash												ļ		
Unapproved FAULT CATEGORY															
Landi	ing Go					General	AUL	.i CATC	GORT				•		
Lanci	Landing Gear Bending					Bend	Г	Grain			Ovalized			Pressure/Forced	
	Centre Not Concentric to O/S					BOM/Route		Hardware			Over/Under	tolerance	-	Temperature/Cure	
	Cracks					Broken/Damaged	-	Inspection Incomplete			Part Incorred			Weld	
	Crushed/Crimped.					Burrs	 	Instructions Incomplete/Unclear			Part Lost/Mi			Wrong Stock Pulled	
	Cuffs					Contamination	\vdash	Maintenance			Part Moved		ـــا	111110011111111111111111111111111111111	
	Heat Treat					Countersink	-	Mislabe			Positioned V	Vrong			

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish